Work Order ID Wednesday, April 17, 20		М		*100	1069*			5/2	110	Jone 18	Page 1
Item ID: D3926 Revision ID:	-3	a Total Production		Accept	*N900	040	100	)* s	Setup Sta	I Z	S1*
Start Date: 4/17/20 Required Date: 4/18/20 Reference:	-	ety: 4.00 Qty: 4.00	*4* *4*		Cust Item I Customer:	D:		#	310	۳ <b>*N</b>	S2*
Approvals: Proce QC:	ss Plan:	MF	Date: 13-4			ate:		F	Run Sta Sto	" <b>[\]</b>	R1* R2*
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	•									
D3926	Rev A										
100				0.00							
*100* Waterjet FLOW CNC Waterjet			Dwg D3926	0.00	•			4	0		JM13-4-17
UHMWB 1.00"		Dwg Rev:_ Prog Rev:_ 2-Deburr if	<del>'/\\</del>								
110 * <b>11</b> 0*	QC2- Insp	ect parts off m	nachine FAI/FAIB	0.00				¢	^		9 211

0.00

Memo

Quality Control

									DQA:	Date:		
NCR: Yes	/ No				WORK ORDER NON-O	CONFORM	MANCE / UP		QA Closed:	Date:		
Work Order:					DISPOSITION			AGAINST DE	PARTMENT			
Part No.					Rework Scrap	י   [	Skid-tube Machining	Crosstube Small Fab	1	Water Jet	Engineering Quality	
NCR No.					Use-as-is Work Order Update	Inern	noforming Large Fab	Finishing Composite	Kec/Sto	re/Packaging Supplier	Other	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data												
quip/Tooling	]											
perator											,	
// Aaterial		ł							1			

## **Landing Gear** General Pressure/Forced Ovalized Bending Bend Grain Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Part Moved Cuffs Maintenance Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread **Drill Holes** Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

**FAULT CATEGORY** 

Setup
Other
Process
Supplier
Training
Unapproved

Work Orde Wednesday, Apri					*100	<b>069</b> *			,				Page :
Revision ID:	D3926-3 Wedge				Accept	*N9(	<b>1004</b> 0	1100	)*	Setup	Start Stop	*N:	S1*
	4/17/2013 4/18/2013	Start Qty: 4.00 Req'd Qty: 4.00		*4* *4*		Cust I Custor	tem ID: ner:					IV.	
Approvals:	Process Pla	an:	Date:		Tooling:		Date:	_ '	1	Run	Start	*N	R1*
•							Date:				Stop	*N	R2*
Sequence ID/ Work Center ID	)	Operation Description			Set Up/ Run Hours	Tool	ID Tool	# Plan Code	Accept Qty	Rejo Qty		leject Iumber	Insp. Stamp
*120 *120* QC		QC8- Inspect parts - seco	nd check		0.00	•			4			·	
Quality Control					B.4	18				,			
130					0.00								
*130* Small Fab		Memo 1- Deburnif r	1ecessarv		0.00					··· ·· ·· · · · · · · · · · · · · · ·			
		, seemily	lecessial y		Alm								,
140		QC5- Inspect part comple	teness to ste	p on W/O	0.00								
*140* QC Quality Control		Memo			0.00								

NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UP	DATE	•		
										QA Closed:	Date	•
	<u>.</u>				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
Work Orde	r:				Rework	7 I		Skid-tube	Crosstube	ד	Water Jet	Engineering
Part N	0				Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raitiv	··				Use-as-is	┥╏┰		noforming	Finishing	⊣	e/Packaging	Other
NCR N	0.				Work Order Update	<b>   </b>		Large Fab	Composite	1	Supplier	1 1
						<b>-</b>		·	·	<u> </u>		
Root				Descri	iption of work order update	Init	tial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data	_											
quip/Tooling	_											•
Operator	_											
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etup	_											
Other	_											
rocess	_											·
upplier	-		}			Ì						
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Inapproved		1	ļ			AULT (	CATE	GORY				<u> </u>
Landin	g Gear				General	AULI	CATE	<u> </u>	<u> </u>	·		
[	Bending			Г	Bend	Пы	rain		Г	Ovalized	Γ	Pressure/Forced
-	Centre N	ot Conce	ntric to	o/s $\vdash$	BOM/Route	$\vdash$	ardwa	re		Over/Under	tolerance	Temperature/Cure
•	Cracks				Broken/Damaged	$\vdash$		on Incomplete		Part Incorred	<u> </u>	Weld
ļ	Crushed/	Crimped			Burrs	In	structi	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	-		T	Contamination			nance		Part Moved		- <del></del>
Ī	Heat Trea	at			Countersink	М	lislabe	led		Positioned V	Vrong	_
Ī	Inspectio	n Strip in	Tube		Cut Too Short	М	lisread	I		Power Loss/	Surge	Other
[	Ripples in	n Bend			Drill Holes	Of	ffset					
	Torque V	Vaves in I	Extrusio	n [	Drawing	o	ut of C	Calibration				
	Turning S	Sequence			Finish	0	ut of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Wednesday, Apr				*100	1069*						Page 3
Item ID: Revision ID: Item Name:	D3926-3 Wedge			Accept	*N900	<b>040</b>	100	)*	Setup Star	1/1	S1* S2*
Start Date: Required Date: Reference:	4/17/2013 4/18/2013	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:			Run Sta	<sup>rt</sup> *N	R1*
	QC:			_	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II 150 *150* Packaging Packaging	<b>D</b>	Operation Description Identify as per dwg & St  Memo	ock Location:	Set Up/ 'Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		QC21- Final Inspection	- Work Order Release	0.00							

0.00

Memo

\*160\*

Quality Control

ML5 13-04-18 MF 13-4-18

										DQA:	vate:	* * * * * * * * * * * * * * * * * * * *
NCR:	res / No				WORK ORDER NON-C	O	NFORM	/ANCE / UPI	DATE	QA Closed:	Date:	
								<del></del>				
Work Orde	er:				DISPOSITION				AGAINST DE	:PARTMENT	/PROCESS	
Part N				······································	Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
IVERT					Work Order Opdate	1		carge rab	composite	J	Supplie!	
Root		T		Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data							·	]				
Equip/Tooling						ł		I				
Operator	•			· .	·			I				
Material								I				
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						AUL	T CATE	GORY				
Landi	ng Gear			_	General	_	1		<u>-</u>	<b>1</b>		1
	Bendin			_	Bend	<u>_</u>	Grain			Ovalized		Pressure/Forced
	<b></b>	Not Conce	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		-	Over/Under	<del></del>	Temperature/Cure
	Cracks				Broken/Damaged	$\vdash$	4 ·	on Incomplete		Part Incorre		Weld
	<b>—</b>	d/Crimped			Burrs	_	4	ions Incomplete/L	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			L	Contamination	$\vdash$	Mainte			Part Moved		
	Heat Tr			-	Countersink	<u>_</u>	Mislabe		<b> </b> _	Positioned V		I
	I linspect	ion Strin ir	Tube		Cut Too Short	1	Misread	i		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Page 1

Work Order ID:

100069

Parent Item:

D3926-3

Parent Item Name:

Wedge

Start Date: 4/17/2013

Required Date: 4/18/2013

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	1,232.0550	0.2423	.1. <del>020210</del> 5	-		Jm13-4-
				Location		Loc Qty	Lo	oc Code					
				MAT019		1232.054989							
				12	1278	12.0949895							
				. 12	2575	47.6							
				12	3229	53							
				12	3704 <sup>-</sup>	63.8							
				12	3949	6.96							
				12	4382	271			19r	1383			
				12	4758	377.6						*	
				12	5137	400							

					•						DQA:	Date	2:
NCR: Y	⁄es	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UP	DATE	QA Closed:	 Date	·
		<u>·</u>		· · · · ·		DISPOSITION	i		· · · · · · · · · · · · · · · · · · ·	AGAINST DE			
Work Orde	-					Rework Scrap			Skid-tube	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root					Descri	ption of work order update	ı	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		,											
опарргочец	1					F/	AUL	T CATE	GORY	•	<u> </u>		
Landi	ng G	iear				General						, · · · · ·	
		Bending Centre No Cracks		ntric to	o/s	Bend BOM/Route Broken/Damaged		4	on Incomplete		Ovalized Over/Under Part Incorred	et [	Pressure/Forced Temperature/Cure Weld
		Crushed/( Cuffs Heat Trea	·			Burrs Contamination Countersink		Mainte Mislabe		Unclear	Part Lost/Mi Part Moved Positioned V	_	Wrong Stock Pulled
	$\boldsymbol{\vdash}$	Inspection	-	Tube		Cut Too Short		Misread	i		Power Loss/:	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

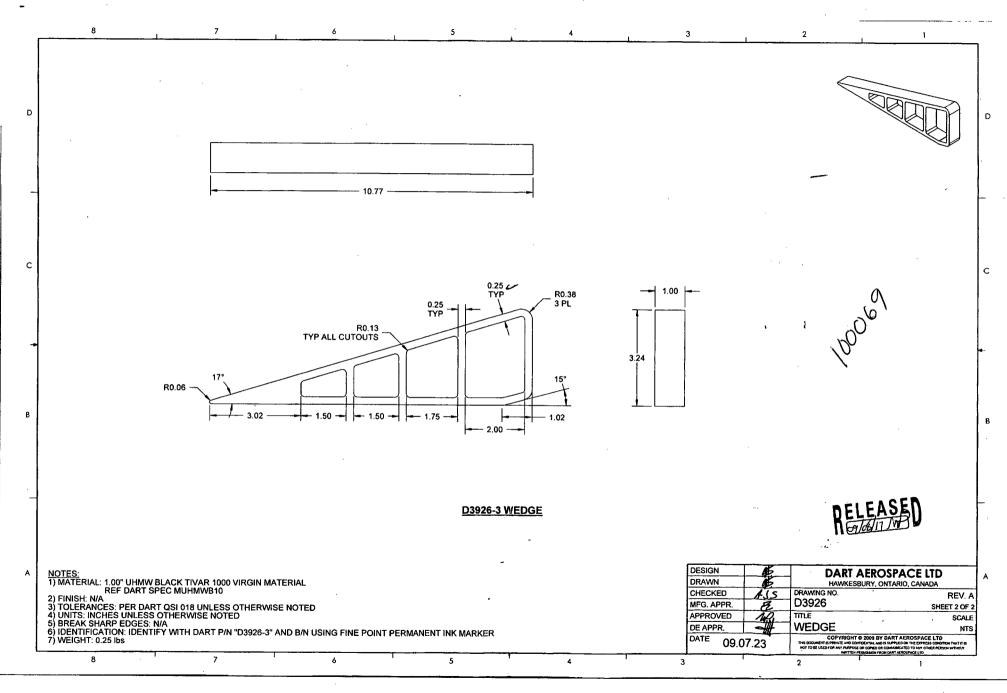
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORI	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Orde	er: _					DISPOSITION				_	EPARTMENT,	_	,
Part N	_			· · · · ·		Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	П				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	[ (	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
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Process	Ш						İ						
Supplier	Ш						l						
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	—	Bending Centre No	t Canca	ntria ta		BOM/Route	$\vdash$	Hardwa	ro	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Н	Cracks	of Conce	illic to	<sup>0</sup> / <sub>3</sub>  -	Broken/Damaged	-	4	ion Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld
·   .	$\vdash$	Crushed/0	Crimned		<u> </u>	Burrs		4	ions Incomplete/l	Inclear	Part Lost/Mi		Wrong Stock Pulled
	-	Cuffs	crimped			Contamination		Mainte			Part Moved		]
		Heat Trea	ıt			Countersink	$\vdash$	Mislabe		<b>-</b>	Positioned V	Vrong	
	-	Inspection		Tube	-	Cut Too Short	$\vdash$	Misread		<u> </u>	Power Loss/	_	Other
	-	Ripples in			<u> </u>	Drill Holes		Offset		<u> </u>		~ <u>L</u>	· · · · · · · · · · · · · · · · · · ·
	-	Torque W		Extrusio	n	Drawing		Out of	Calibration				
	-	Turning S				Finish		Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

DART AEROSPACE LTD	Work Order:	100069
Description: Wedge	Part Number:	D3926-3
Inspection Dwg: D3926 Rev: A	· · · · · · · · · · · · · · · · · · ·	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

XF	First Article	Prototype	
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.02	+/-0.030	3022~	_		V	Jamos .
1.50	+/-0.030	1.504"	_		V	
1.50	+/-0.030	1.507	_		V	
1.75.	+/-0.030	1.746"			ν	
2.00	+/-0.030	1.995	-		V	
1.02	+/-0.030	1.02	-		V	
0.25	+/-0.030	B,248°	_		V	
0.25	+/-0.030	0.259"	_		V	
3.24	+/-0.030	3.2us~	_		V	
1.00	+/-0.030	1.011"	Nage-		V	
10.77	+/-0.030	10,77"			V	Produtora
,						
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	· · · · · · · · · · · · · · · · · · ·	<u>:</u>			
Measured by:	Im	Audited by:	27	Prototype Approval:	N/A
Date:	13-4-17	Date:	13415	Date:	N/A
		L	, , , ,	L	

Rev	Date	Change	Rev	ised t	У	Approved
Α	09.09.17	New Issue	KJ	40	_	_///
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W.,									DQA:	Date:	×
NCR: Y	es / No		•		WORK ORDER NON-	CONFORM	IANCE / UP	PDATE		,	and the second s
									QA Closed:	Date:	
Work Order:					DISPOSITION AGAINST D			EPARTMENT			
Part No.					Rework Skid-tube Crosstube Scrap Machining Small Fab			Pro	Engineering Quality		
NCR N	lo		•		Use-as-is Work Order Update	I	oforming	Finishing Composite	_ Rec/Stor	e/Packaging Supplier	Other
Root		T	<del></del>	Descri	ption of work order update	Initial	A(	ction	Sign & -		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data				,							,
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Operator		·	`							٠	
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Landin	ng Gear				General	<u>.</u>			_		
	Bending Centre Not Concentric to O/S				Bend -	Grain			Ovalized		Pressure/Forced
					BOM/Route	Hardward	e		Over/Under	tolerance	Temperature/Cure
	Cracks		,	· [	Broken/Damaged:	Inspection Incomplete Instructions Incomplete/Unclear			Part Incorred	t 1 <u> </u>	Weld
	Crushed/	Crimped	1 -	٠ - ١	Burrs				Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination Maintenance			Part Moved			
	Heat Trea	at			Countersink	F-1			Positioned V	Vrong	
	Inspectio	n Strip ir	1 Tube		Cut Too Short				Power Loss/	Surge	Other
	Rinnles in Bend			*	Drill Holes	Holes Offset					e e S

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish